

Split

Dart Aerospace Ltd.

Friday, 11/18/2005 3:15:04 PM
Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MID TUBE ASSEMBLY
Job Number : 24866 A
Estimate Number : 10469
P.O. Number : N/A Part Number : D3391023
This Issue : 11/18/2005 S.O. No. : N/A Drawing Number : D3391 REV C
Print Rev. : NC Project Number : N/A
First Issue : N/A Type : LANDING GEAR Drawing Revision : C
Previous Run : 24442 Material : N/A
Written By : See comment below Due Date : 12/20/2005 Qty: 5 Um: Each
Checked & Approved By : See comment below
Comment : Est. A 05.10.20 New Issue KJ/EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D25001100

Skidtube Extrusion



Comment: Qty: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-100	Extrusion	B24593

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 as per Dwg D3391

4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.438" as per Dwg D3391

7-Remove indexing ridge on aft end of skidtube as per Dwg D3391

8-Deburr

9-Drill #30 pilot holes using wearplate Jig DT8217/Identify Ø0.208" holes with paint marker

10-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.208" (14 holes) as per Dwg

D3391

11-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250"

and c'sink (20 holes)

as per Dwg D3391

12-Deburr and blow out all chips from inside tube

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

206-01-09

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 24866

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 ~~15-01-07~~ 9m 06-01-07 (2)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

J 06 01 07

6.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

WEB

Pick:

Qty

Part Number

Description

Batch

1

D33891

Web

B 24886

A/R

Sikaflex-241/-291

M 19134

am 06-01-07 (2)

Sikaflex expire date:

06-06-20

Start: 06-01-07 Time: 11:15

Finish: 06-01-07 Time: 8:10 A.M.

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

9m 06-01-07 (2)

8.0

NAS1330C3KB116

Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total: 100.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

20

NAS1330C3KB116

Insert

M 19014

FC 06 01 09

9.0

NAS1330C3KB166

Rivnut



Comment: Qty.: 10.0000 Each(s)/Unit Total: 50.0000 Each(s)

Rivnut

Pick:

Qty Part Number

Description

Batch

10

NAS1330C3KB166

Insert

M 19354

FC 06 01 09

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 24866

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0
~~11.0~~
12.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Install inserts as per Dwg D3391

FC 06 01 09

11.0
~~12.0~~
13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06 01 12

12.0
~~13.0~~
10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Use paint screws to mask inserts.

MD 06 01 09

13.0
~~14.0~~
11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06 01 12

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SAC 06/01/12 (2)

06/01/12

Job Completion



